

Work Order ID 52544

September 30, 2009 10:09:06 AM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Bracket

Start Date: 02/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3264	Rev A2								

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

DIT 09/09/30

10

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447

FOLIO REV: A

DWG REV: A

DEBURR AS PER DWG

0.00

HA 09/10/02
DIT 09/10/03

[illegible]

September 30, 2009 10:09:06 AM

Accept

[illegible]**Setup Start**

Stop

**Cust Item ID:****Required Date:** 06/10/2009 **Req'd Qty:** 10.00

Customer:

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

[illegible]

QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

0.00

[illegible]

QC

Memo

0.00

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00.

[illegible]

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 52544

September 30, 2009 10:09:06 AM



Page 3

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Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112260 START 11:15. BR 09-10-5
Memo OVEN 320° 0.00
FIRST 11:45

(10)

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

PC 9/16/06 (10)

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

PC 9/16/06 (10)

Work Order ID 52544

September 30, 2009 10:09:06 AM



Page 4

Item ID: D3264-1

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Bracket

Start Date: 02/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/09

MF 09-10-06

Picklist Print

September 30, 2009 10:09:02 AM

Page 1

Work Order ID: 52544



Parent Item: D3264-1RevA2



Parent Item Name: Bracket

Start Date: 02/10/2009

Required Date: 06/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	52.8096	5.0000			



6061-T6 Bar 1.25 X 4.50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	52.8096	
105531	0.19	
108855	0.27	
109401	0.82	
111486	3.5296	
112628	48	

5.0 DIA 09/09/30

DART AEROSPACE LTD		Work Order: 52544
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.688	✓			
0.063	+/-0.010	0.063	✓			
0.125	+/-0.010	0.1265	✓			
0.875	+0.010/-0.020	0.877	✓			
0.062	+/-0.010	0.0600	✓			
R0.03	+/-0.030	0.03	✓			
R0.13	+/-0.030	0.13	✓			
1.00	+/-0.030	1.005	✓			
0.125	+/-0.010	0.123	✓			
0.600	+/-0.010	0.599	✓			
4.000	+/-0.005	3.998	✓			
0.750	+/-0.010	0.749	✓			
Ø0.194	+0.005/-0.000	0.196	✓			
5.50	+/-0.030	5.499	✓			
0.125	+/-0.010	0.126	✓			
0.063	+/-0.010	0.064	✓			
R0.25	+/-0.030	0.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	0.300	✓			

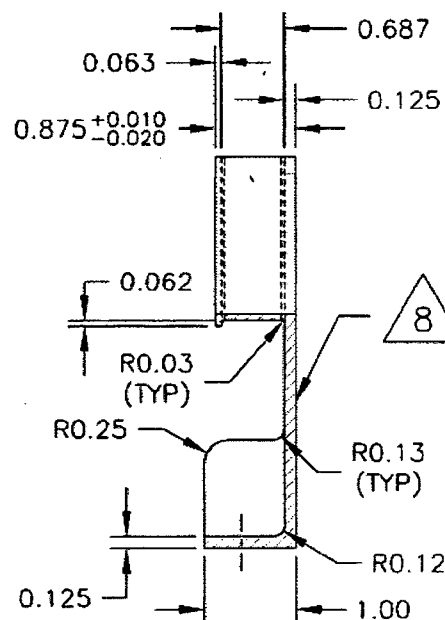
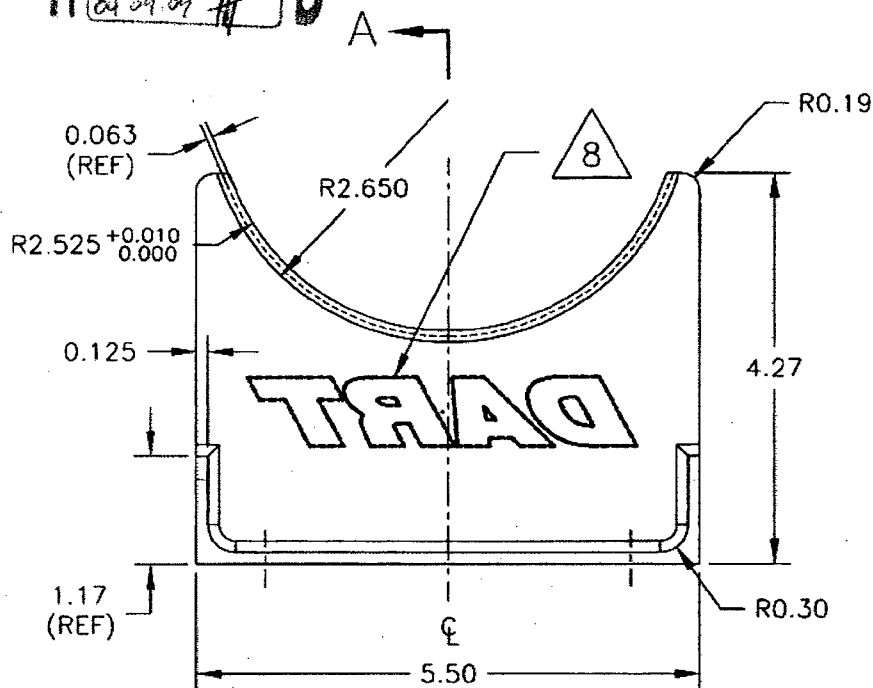
Measured by: DJD	Audited by: SP	Prototype Approval:	N/A
Date: 09/10/03	Date: 09/00/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

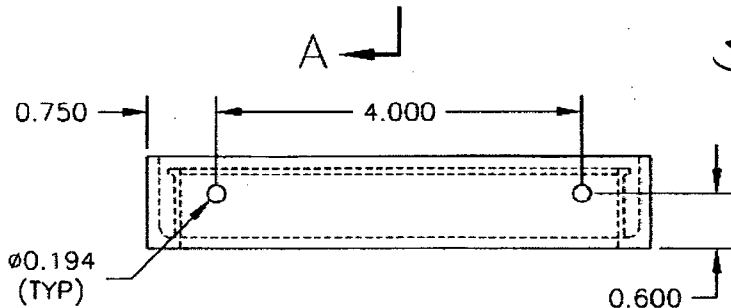


DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

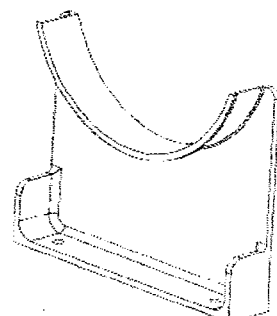
RELEASED
04.09.09 *[Signature]*



SECTION A-A



52544



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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